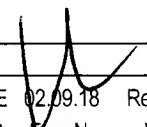
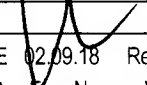


Date Thursday, 16/08/2007 10:22:54 AM
User Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--|------------------|--------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEARPAD |
| Jot Number | : 33992 | | |
| Estimate Number | : 10313 | | |
| P.C. Number | : N/A | Part Number | : D26483 |
| This Issue | : 16/08/2007 S.O. No. : N/A | Drawing Number | : D2648 REV D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : SMALL /MED FAB | Drawing Revision | : D |
| Previous Run | : 33059 | Material | : N/A |
| Written By | :  | Due Date | : 05/09/2007 Qty: 200 Um: Each |
| Checked & Approved By | :  | | |
| Comment | : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev: Now on Waterjet 06-08-14 JLM | | |

Additional Product

Jot Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 0.0788 sf(s)/Unit Total: 15.7500 sf(s)
1010/1025/A21/6aA SHEET
(M1010S16GA)
Batch: M10S 261 B07-08-19

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D2648
*****CUT WITH FILE D2648-1*****
Dwg Rev: D B 07-08-19
Prog Rev: D

200

2-Deburr if necessary

SAP

82/08/26

200

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE
B 07-08-19

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK
In 07/08/20 4200 counter

50 07/08/20

4200

counter

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:22:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33992

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAD 07/10/26

counted

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 07/10/28

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R560Hardcoat

M105887/M105844 FC/2S 07/11/09

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD

07-11-12 (200)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD

07-11-12 (200)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

FL

07/11/12 (200)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. J. 07/11/12

(200x)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP 17

M. J. 07/11/12

(200x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/11/13
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:22:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33992

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(Signature)
D 07/11/13

Job Completion



U 07-11-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

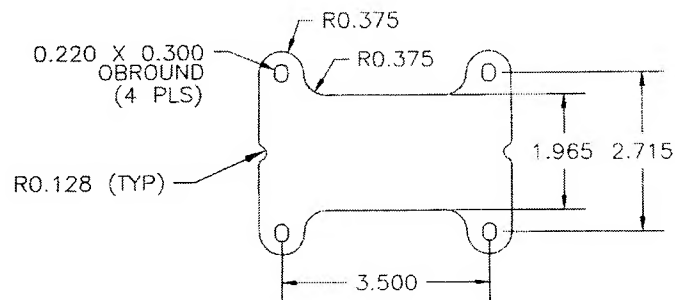
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

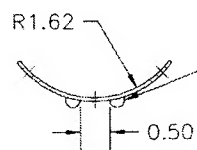
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

D2648-1 FLAT PATTERN

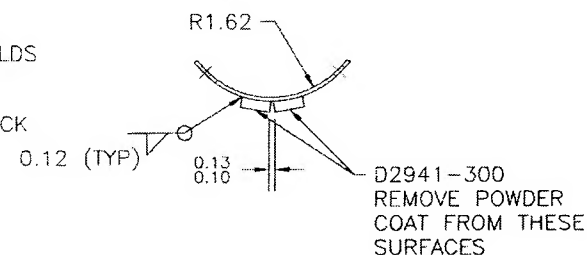


SECTION A-A

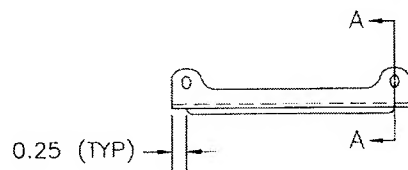


7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

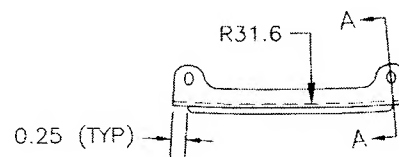
SECTION B-B



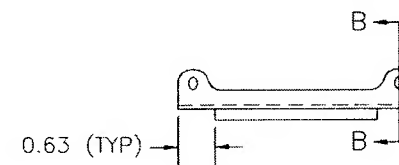
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED
1997.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

| | | |
|----------|----------|---|
| D | 99.11.17 | ADDED D2648-7 |
| C | 97.06.26 | R31.6 WAS R19.6 |
| B | 97.05.30 | ENLARGE OBOUND, 0.375 WAS 0.250 |
| A | 97.03.25 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. BELLVILLE, TX |
| CHECKED | APPROVED | DRAWING NO. D2648 |
| DATE | TITLE | SCALE |
| 99.11.17 | WEARPAD | 1:2 |

CUSTOMER RETURN

Initiator: Jan Kerr
Company: Rotortech Services Inc.
CRO TOL
Phone No: 561-684-6000

REFERENCE ONLY Date: March 18/08
Invoice # 6092
Order Entry # 5622

Reason for return: PADS NOT compatible with OEM tubes
Attach Copy of DHS Return Authorization # 383

Receiving: 8/9/07 Freight Company: 1-10164 Prepaid Collect

| # | Part # | Batch # | Description | Distribute to QC | |
|----|---------|---------|-------------|------------------|-------|
| | | | | Advise QA | Date: |
| 10 | D2648-3 | 33992 | Wear pads | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

Condition of packaging: _____ Photograph required: yes no

Paperwork attached: P/S _____ Invoice P ARC _____ Docs _____ Other _____

QC:

Quarantine: _____ Location: _____ Condition of Part: good

Inspect: _____ Initial: P

| # | Part # | Batch # | QC Comments | QC Approval | | Scrap |
|----|---------|---------|----------------------------|-------------|-------|-------|
| | | | | Initial | W/O # | |
| 10 | D2648-3 | 33992 | return to stock as per inv | <u>P</u> | 38886 | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

QA Coordinator:

Advise GM as to findings: _____ Initial: _____ Date: _____

Comments: _____

Issue credit: yes no

GM Approval: _____ Date: _____

Invoice Amount: _____
Less Replacement: _____
Restock Fee: _____
Freight: _____
Net Credit: _____
DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit